

20-8065



Dart Aerospace Ltd.
1270 Aberdeen St
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D2858-1**Job Sheet 198455****Part No:** D2858-1**Job Qty:** 20 pcs**Part Name:** Hinge Bracket

21 pcs

**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/30/19**Job Tracking No:****Due Date:** 8/19/19**Created By:** Marie Lajeunesse**Type:** SOLD *STC***Description:****Note:** DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs		8/19/19	0.00	0.10	Bandsaw - 1		
110	HAAS 4 Axis - B4B	20 pcs		8/19/19	1.00	5.58	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		<i>SBL</i>
							HAAS - 4 - B4B		
130	QC 8	20 pcs		8/19/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		<i>Am 19/09/20</i>
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



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Container No: S214440**Part:** D2858-1**Job No:** 198455**Serial No/Batch:** S214440**Revision:** C**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 09/17/19

140	Handfinish - 1-1 Chemical-B4B	20 pcs	8/19/19	0.00 0.22	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	SEP 23 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White Gl(A)-B4B	20 pcs	8/19/19	0.00 0.26	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160	QC 3	20 pcs	8/19/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	

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40
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					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	SEP 23 2019
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	20 pcs	8/19/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	P= 5010
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180	QC 21 - SA	20 pcs	8/19/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut blanks 5.850 " Note: 1 Blank Makes 3 Parts

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FA941 FOLIO REV: AA DWG REV: C 2-Deburr any rough edges

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: OVEN TEMPERATURE:

FINISH TIME:

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location:)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X1.500	6061-T6 Bar 1.250 X 1.500 2.000	3.2600 ft (.163 ea)	100-Bandsaw - 1	5202 789

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X1.500 2.000 inf	3	20	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	0.171inches + 0.005 - 0.001	0.176 0.170		
2	Hinge Bracket	0.400inches + 0.006 - 0.001	0.406 0.399		
3	Hinge Bracket	0.125inches ± 0.010	0.135 0.115		
4	Hinge Bracket	0.328inches ± 0.010	0.338 0.318		
5	Hinge Bracket	0.820inches ± 0.005	0.825 0.815		
6	Hinge Bracket	1.476inches ± 0.010	1.486 1.466		
7	Hinge Bracket	0.342inches ± 0.010	0.352 0.332		
8	Hinge Bracket	0.875inches ± 0.005	0.880 0.870		
9	Hinge Bracket	1.560inches ± 0.030	1.590 1.530		
10	Hinge Bracket	0.147inches ± 0.010	0.157 0.137		
11	Hinge Bracket	0.717inches ± 0.010	0.727 0.707		
12	Hinge Bracket	0.697inches ± 0.010	0.707 0.687		
13	Hinge Bracket	0.229inches ± 0.010	0.239 0.219		
14	Hinge Bracket	0.125inches ± 0.010	0.135 0.115		
15	Hinge Bracket	0.063inches ± 0.010	0.073 0.053		
16	Hinge Bracket	0.063inches ± 0.010	0.073 0.053		
17	Hinge Bracket	0.126inches ± 0.010	0.136 0.116		
18	Hinge Bracket	0.630inches ± 0.010	0.640 0.620		
19	Hinge Bracket	0.354inches ± 0.010	0.364 0.344		
20	Hinge Bracket	0.965inches ± 0.010	0.975 0.955		
21	Hinge Bracket	0.166inches + 0.005 - 0.000	0.171 0.166		
22	Hinge Bracket	0.125inches ± 0.010	0.135 0.115		
23	Hinge Bracket	32.700Degrees ± 0.500	33.200 32.200		

Plex 7/30/19 8:26 AM Dart.lajeunesse.marie

Entered: 2L Date: Apr 13/2020



NCR No. 20-8065 **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

Job: <u>198 455</u> Part No. <u>D2858-1</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
Date: <u>19/09/16</u>		Sequence #: <u>110</u>		QTY Affected: <u>8 21</u>		MRB (QSI042) DAS 55 9-89 Completed By DAS 57 9-89 <u>19/09/16</u> Lead hand / Supervisor <u>ork</u> <u>19/09/16</u> QC / QA Coordinator 68 9-89 SEP 16 2019																													
Description Work Order Deviation I took a I used the wrong tool for roughing, I put a 1/2 rougher instead of 3/8 rougher result the piece are too small				Disposition <u>scrap and replaced</u>																															
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☒		FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☒ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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		Other/Details: <u>I did not notice</u>																																	